

Work Order ID 62468

Thursday, September 30, 2010 12:45:01 PM



Page 1

Item ID: D2804-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 9/30/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-9-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2804	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per File D2804-1-2_Blank

6061 .500x 12"

Dwg Rev: *[Signature]*

Prog Rev: *[Signature]*

2-Deburr if necessary

B10-10-5

(4)

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA103

mk 10/12/15

(4)

B10-10-5

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mk 10/12/15

4

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62468

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Page 2

Item ID: D2804-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 9/30/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

G.A 10/12/16

4

Ø

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

H

BR 10-12-16

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

6-A
w/o
62072

6/50/10/16 (E)

W/O:		WORK ORDER CHANGES					
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Work Order ID 62468

Thursday, September 30, 2010 12:45:01 PM

Page 3

Item ID: D2804-1

Accept

Revision ID:

Item Name: Bracket

Start Date: 9/30/2010 Start Qty: 4.00

Required Date: 10/8/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/10 [Signature]
MK
10-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 30, 2010 12:45:06 PM

Page 1

Work Order ID: 62468



Parent Item: D2804-1



Parent Item Name: Bracket

Start Date: 9/30/2010

Required Date: 10/8/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 00.11.06 ☐ New Issue ☐ EC ☐
IPP B 06.05.30 Blanks on wtjet ☐ EC ☐
IPP Rev:C As per Rev C 06-11-09 JLM
IPP Rev:D Removed Tumbling 08-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X12.00 0		Purchased	No			100	f	32.8000	0.75	3.157895			



6061-T6 Bar .500 x 12.00



10-10-5

Location

Loc Qty

Loc Code

MAT07

32.8

111382

32.8

111382

(4)

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DART AEROSPACE LTD		Work Order:	62468
Description: Bracket		Part Number:	D2804-1
Inspection Dwg: D2804	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø.760	—		Micr	ML-01
Ø0.191	+0.005/-0.001	Ø.194	—		Vern	ML-7
1.420	+/-0.001	1.414	—		n	n
Ø0.507	+0.000/-0.001	Ø.5068	—		Micr	ML-01
0.250 deep	+/-0.010	.250	—		Vern	ML-7
Ø0.507	+0.000/-0.001	Ø.5068	—		Micr	ML-01
Ø0.191	+0.005/-0.000	Ø.194	—		Vern	ML-7
6.933	+/-0.010	6.933	—		M-tape	ML-2
7.578	+/-0.010	7.578	—		"	"
12.304	+/-0.010	12.304	—		"	"
0.125	+/-0.010	.127	—		Vern	ML-7
0.500	+/-0.010	.501	—		"	"
0.125	+/-0.010	.127	—		"	"
0.250	+/-0.010	.249	—		"	"
0.875	+0.000/-0.001	.875	—		Micr	ML-01
0.250	+0.000/-0.005	.248	—		Rept-gage	ML-05

Measured by:	AmL	Audited by:	B.A	Prototype Approval:	N/A
Date:	10/12/15	Date:	10/12/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.06.05	Removed dimensions 12.625, 0.608, 0.437, 2.654	KJ/EC	
C	06.11.10	Revised per drawing revision C	KJ/JLM	
D	09.03.10	Tolerance revised for Ø0.757	KJ/DD	

W/O:		WORK ORDER CHANGES					
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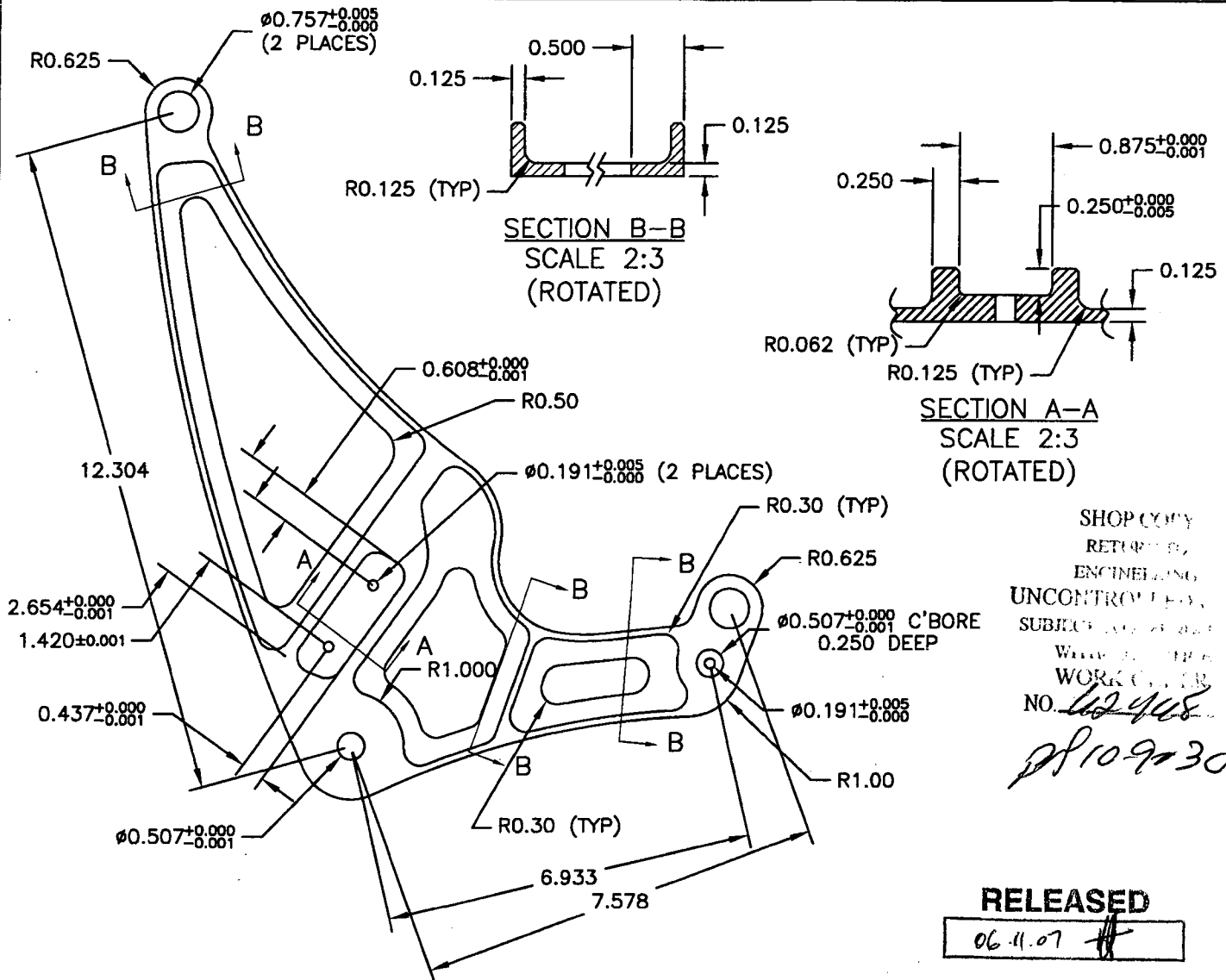
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE	06.10.16			TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	
C	06.10.16			CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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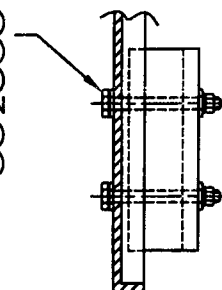
NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
				D2804	SHEET 2 OF 2
DATE	06.10.16	TITLE	STA 155 BRACKET	SCALE	1:3

u/o 62468

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21042-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)

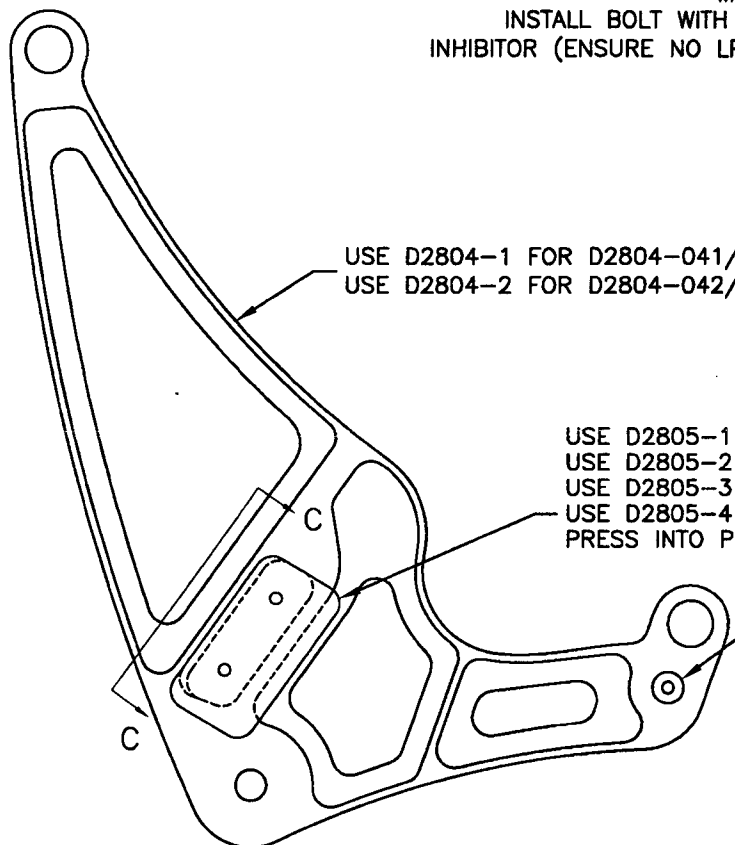


SECTION C-C
SCALE 1:3
(ROTATED)

USE D2804-1 FOR D2804-041/-043
USE D2804-2 FOR D2804-042/-044

USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT



RELEASED

06.11.07 *[Signature]*

D2804-041/-043 BRACKET ASS'Y (SHOWN).

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Dart Aerospace Ltd

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